

Date: Friday, 03/04/2009 10:19:30 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL TUNNEL TOP
Job Number : 46914	
Estimate Number : 13588	
P.O. Number :	Part Number : D38225
This Issue : 03/04/2009 S.O. No. :	Drawing Number : D3822 PRELIMINARY
Prsht Rev. : NC	Project Number : IN0002
First Issue : // Type : THERMOFORMING	Drawing Revision : B PRELIMINARY
Previous Run : 44460	Material : MKYD6185S080P362015
Written By :	Due Date : 10/04/2009 Qty: 2 Um: Each
Checked & Approved By : <u>JUD 09.04.03</u>	
Comment : Est. A New Issue 08/09/17 DL Rev B Dwg. Update 09/02/09 DL verified by:DD	

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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Comment: Qty.: 1.5000 sf(s)/Unit Total: 3.0000 sf(s)
 6185 Kydex .080"

M109703

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/04/06

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/04/06 / X2

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-5 and folio FTA 028 using tool DT 9078

Dwg. Rev. B
 Folio Rev. B

BB 09/04/06 / X2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 03/04/2009 10:19:30 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL TOP

Job Number: 46914

Part Number: D38225

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/04/08 (x2)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 09/04/08 (x2)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/04/08 (x2)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/08 (x2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/15 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

POSITIVE RECALL

EFFECTIVE 09/04/08 AUTH 11

RELEASED 16 DATE 09/04/14

09/04/15 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15 (2)

Job Completion



u 09/04/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 46914
Description:	Part Number: D3822-5
Inspection Dwg: D3822 Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/04/08

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.3	Min	.364	✓			
10.0		10.05	✓			
3.2		3.25	✓			
.040	Min	.058	✓			
.060	Min	.074	✓			

Measured by: BB

Date: 09/04/08

Audited by: [Signature]

Date: 05-04-15

Prototype Approval: [Signature]

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



